

Work Order ID 71184

Thursday, June 23, 2011 11:16:52 AM



Page 1

Item ID: D3756-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Cushion

Start Date: 6/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/06/23 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3754	Rev D
D3756	Rev C

100 PURCHASING 0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: 14369
Manufacture D3754-1as per Dwg D3754
Upholster as per Dwg D3756
Supplier: Aerotex
Material release note is required

CL 11/06/24 (4)

110 Receive & Inspect for Damage & Mat'l Certs 0.00



Packaging

Memo

0.00

Packaging

Rec'd 7/5 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71184

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Page 2

Item ID: D3756-041

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Setup Start



Revision ID:

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Item Name: Cushion

Start Date: 6/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

5 m2/07

(x4)

Quality Control

130

Identify as per dwg & Stock Location 252A

0.00



Packaging

Memo

0.00

Packaging

11/7/8 (40) [Signature]

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/2/11 [Signature]

MF
11-07-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 11:16:50 AM

Page 1

Work Order ID: 71184



Parent Item: D3756-041



Parent Item Name: Cushion


Start Date: 6/23/2011

Required Date: 7/5/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A08.11.17 New issue EC verified by: DD IPP
Rev: B 10.04.13 as per Ec10-539 DD verified by: EC IPP Rev: C
10.05.03 remove velcro per comment (W/O 58261) DD verified: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3756-041P  Cushion		Purchased	No			110	Each	0.0000	1	4			

Signature

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -1	PART NUMBER	DESCRIPTION
1	X		D3756-041	CUSHION
2	1	X	D3756-1	COVER
3	1		D3754-1	BACK FOAM
4		A/R	HOOK STRIP, 2"	3M SJ3418FR, 2" WIDE BEIGE OR D3800-1-200-600
5		A/R	LOOP STRIP, 1"	3M SJ3418FR, 1" WIDE BEIGE OR D3800-1-100-700
6		A/R	HOOK LOOP, 1"	APLIX 800, A800R0025H958-1, 1" WIDE BEIGE OR D3800-3-100-700
7		A/R	FABRIC	JACKSON GREYMIX
8	A/R	A/R	THREAD	BONDED POLYESTER, 14.2 lb BREAK STRENGTH, GREY COLOR
9	A/R		ADHESIVE	3M 1300 / 1300L RUBBER AND GASKET ADHESIVE OR SILAPRENE DC12906 SPRAY GRADE HPL CONTACT ADHESIVE

△

△

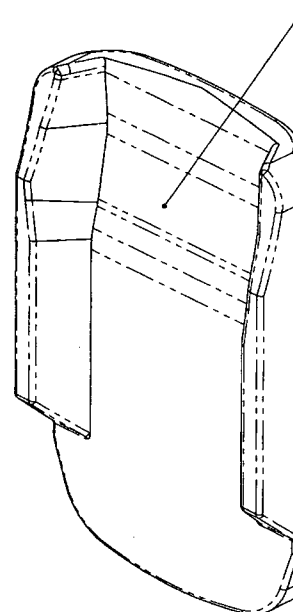
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COVER SHOULD BE TIGHT TO
FOAM IN CONCAVE AREA SHOWN

12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 71189
C211006123

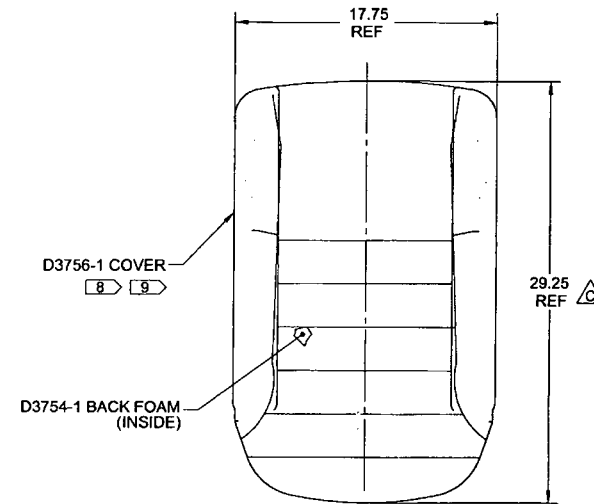
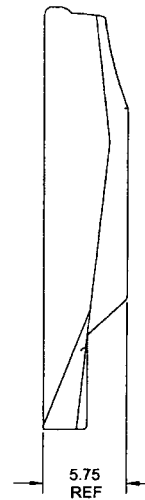
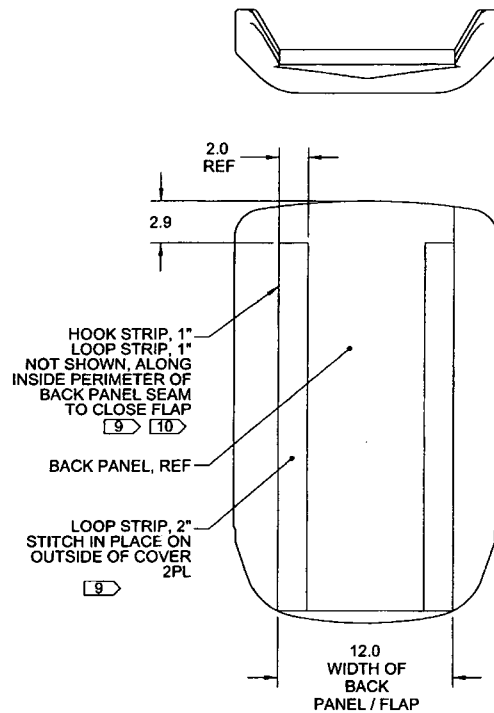
RELEASED
2010-03-23
AM

D3756-041 CUSHION

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3756-041" USING LABEL
- 7) WEIGHT: 4.2 lbs
- 8) SEW D3756-1 COVER TO FIT D3754-1 FOAM
- 9) STITCHING: 4-6 STITCHES PER INCH, USE MIN 1/2" BACKSTITCH, NO LOOSE THREADS
- 10) STITCH HOOK AND LOOP STRIP (1") ALONG EDGE OF SEAM TO CLOSE COVER, INSTALL THE LOOP STRIP ON THE TOP OVERLAPPING FLAP, INSTALL THE HOOK STRIP ON FABRIC NEXT TO FOAM
- 11) CUSHION SHAPE / FORM / PATTERN TO CONFORM WITH TEMPLATE DT9420
- 12) TO PULL FABRIC AGAINST FOAM IN CONCAVE AREAS, STITCH FOAM TO FABRIC AS REQ'D OR BOND WITH SILAPRENE DC12906 SPRAY GRADE HPL CONTACT ADHESIVE OR 3M 1300/1300L RUBBER AND GASKET ADHESIVE

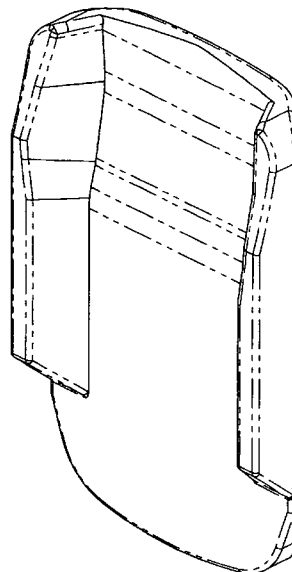
C	UPDATE TO VIEWS/NOTES FOR RE-SHAPPED D3754-1 BACK FOAM & NEW MFR: FABRIC, HOOK, LOOP, ADHESIVE CHG (D5-1); 29.75 WAS 27.00 (C1-2); REF PAR 09-030.	CP	10.02.02
B	COVER NOW CLOSED WITH SINGLE SEAM (ZN A8-1, B8-2), D3800-1-100-300 WAS D3800-1-100-650 (D8-1), D3800-3-100-300 WAS D3800-3-100-650 (C8-1), ADD ITEM NUMBERS TO PART LIST (D8-1), 17.75 WAS 18.00 (D2-2)	CP	08.10.21
A	NEW ISSUE	CP	08.09.09
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JP</i>		
CHECKED	<i>JP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JP</i>	D3756	SHEET 1 OF 2
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	CUSHION	NTS
DATE	10.02.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3756-041 CUSHION

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2010-03-23

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3756	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CUSHION	NTS
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D3754-1 BACK FOAM

RELEASED
2010-03-23
MP

NOTES:

- 1) MATERIAL: FOAMEX H250-35S1 FOAM
OR
AIRFLEX FIRE-RESISTANT AIRCRAFT CUSHIONING, GRADE 30-40 (COLOR: LIGHT GREEN)
SUPPLIER: CHESTNUT RIDGE FOAM INC., P/N 603150-99
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3754-1" USING PERMANENT INK MARKER
- 7) WEIGHT: 2.2 lbs APPROX
- 8) FOAM SHAPE TO CONFORM WITH TEMPLATE DT9028

D	ADD SHT 2; ALL PRIMARY VIEWS MOVED TO SHT 2; DIM 3.00 WAS 4.00 (B8-2); 29.25 WAS 27.00 (C3-2); 6.50 WAS 4.25 (B3-2); ADD FOAMEX MATL (A8-1), REF PAR 09-030	CP	10.02.02
C	CHG DIMS PER CHESTNUT SAMPLE: 17.75 WAS 18.00 (D8-1)	CP	08.10.08
B	REMOVE 'HUMP' IN LOWER PART OF FWD (CONCAVE) SIDE (C5-1)	CP	08.09.09
A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>GP</i>		
DRAWN	<i>GP</i>		
CHECKED	<i>GP</i>		
MFG. APPR.	<i>GP</i>		
APPROVED	<i>MP</i>		
DE APPR.	<i>MP</i>		
DATE	10.02.02		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3754

REV. D
SHEET 1 OF 2

TITLE
BACK FOAM

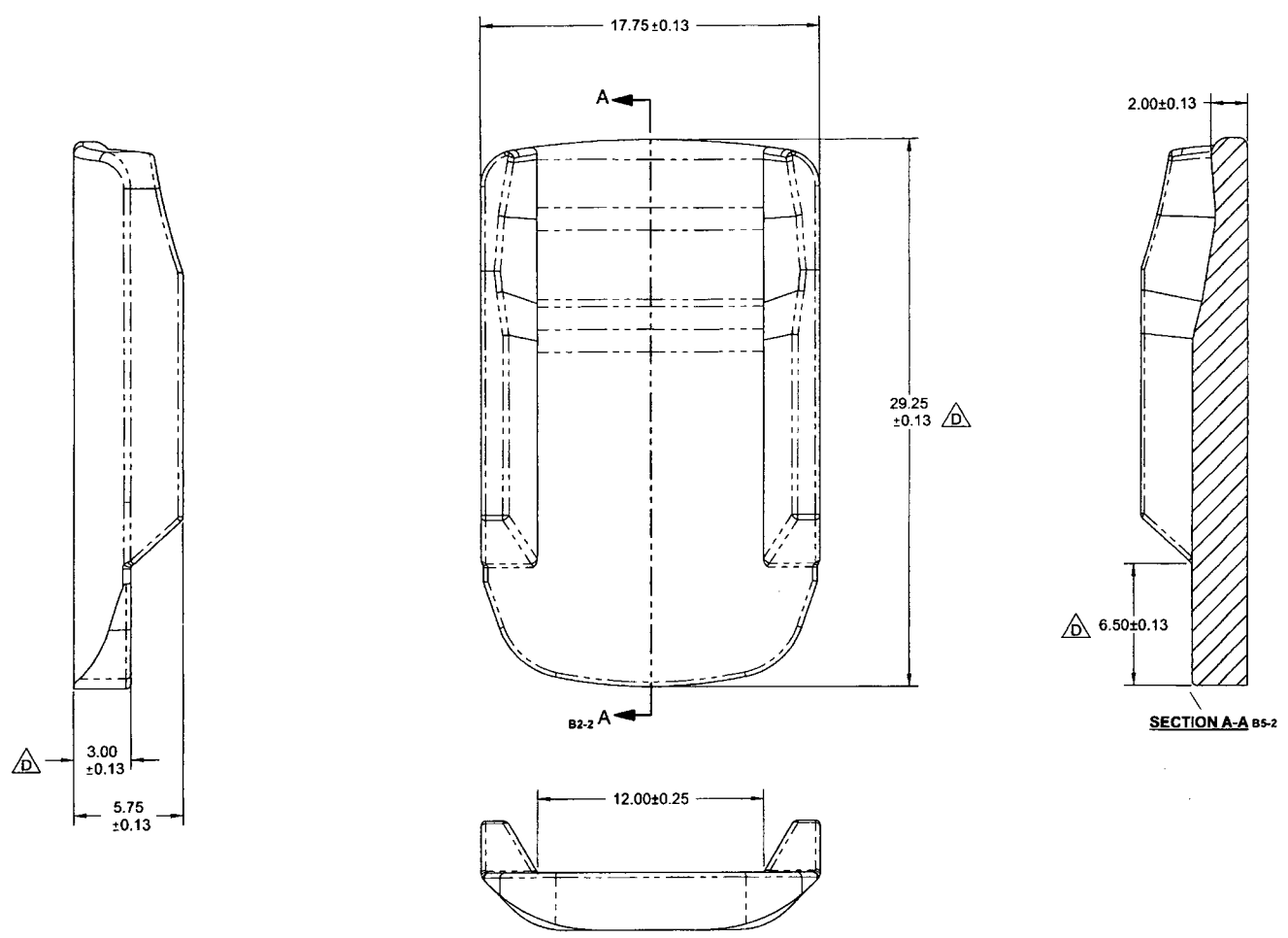
SCALE
NTS

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8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



D3754-1 BACK FOAM

RELEASED
2010-03-23
MO

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3754	REV. D
MFG. APPR.		TITLE	SHEET 2 OF 2
APPROVED		BACK FOAM	SCALE
DE APPR.			NTS
DATE	10.02.02	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1



24 - 2333-18 Avenue NE

Calgary, AB T2E 8T6

PH: 403.295.8770 FX: 403.313.0793

EM: info@aerotex.ca WS: www.aerotex.ca

Packing Slip

Date

Packing Slip#

27/06/2011

8135

Ship:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Bill:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Customer Phone
613.632.5200

Customer Fax
613.632.1053

Email: PURO ACCT 1-7684382

Ship Via
FedEx P1

Courier Acct No.
1517-9324-0

Ship Date

P.O. No.

27/06/2011

14369

Aircraft	Description	Part Number	Qty
DART	SEAT CUSHION	D3755-041P	4
DART	BACK CUSHION	D3756-041P	4
	GST On Sales		

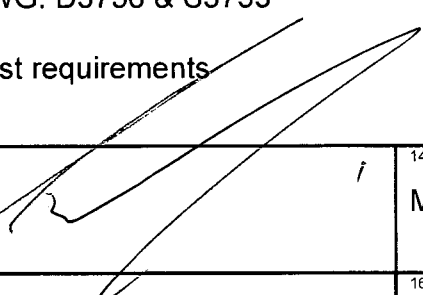
Thank you for doing business with Aerotex Interiors!

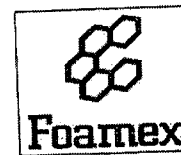
GST/HST No.

139110308

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www.aerotex.ca

1. Organization issuing certificate. Aerotex Interiors Inc., 24 – 2333 18 Ave NE Calgary, AB T2E 8T6		2. CERTIFICATE OF CONFORMANCE			3. Work Order / Contract / Invoice 8135
4. Customer Name DART Aerospace Ltd					5. Customer Purchase Order 14369
6. Item	7. Description	8. Part No./Specification	9. Qty.	10. Batch No.	11. Status
1	1" Velcro Loop – Beige	D3800-1-100-700	NA	5049	NEW
2	1" Velcro Loop – Beige	D3800-3-100-700	NA	5049	NEW
3	2" Velcro Loop – Beige	D3800-1-200-600	NA	5049	NEW
4	Fabric	Jackson Greymix	NA	9	NEW
5	Thread - Bonded Polyester Grey	14.2lb Break Strength	NA	NA	NEW
6	Adhesive	3M 1300/1300L Adhesive	NA	NA	NEW
7	Foam	H250-35S1	NA	5304	NEW
8	Foam	H270-40S1	NA	5304	NEW
12. Remarks I certify that the materials supplied for the Purchase/Repair Order listed above conform to Aerotex Interiors's material/process specification and are in all respects in conformance with the contract requirements. I further certify that the materials meets and complies with DWG. D3756 & S3753 Burn test requirements					
13. Signature 		14. Title Manager			
15. Name Carson Chanthvong		16. Date June 27, 2011			



SALES SPECIFICATION

FOAM GRADE: H250-35S1
COLOR: PEACH

EFFECTIVE: 02-13-01
SUPERSEDES: 12-04-00

TEST ITEM	UNIT	LIMITS	TEST METHOD
DENSITY	PCF	2.37-2.62	ASTM 3574
I.F.D. @ 4" THICK	LBS.	32.0-38.0	ASTM 3574
- 25% DEFLECTION	LBS.	80.0 MIN.	ASTM 3574
- 65% DEFLECTION			
SUPPORT FACTOR	RATIO	2.50 MIN.	
RECOVERY	%	80 MIN.	
HYSTERESIS LOSS	%	20 MAX	
CONSTANT DEFLECTION			
COMPRESSION SET	%	10 MAX.	ASTM 3574
- 90% DEFLECTION	%	8 MAX.	ASTM 3574
- 75% DEFLECTION	%	3 MAX.	ASTM 3574
- 50% DEFLECTION			
STEAM AUTOCLAVE AGING			
- COMPRESSION SET @			
50% DEFLECTION	%	N/A	ASTM 3574
DRY HEAT AGING			
- COMPRESSION SET @			
50% DEFLECTION	%	5 MAX.	ASTM 3574
AIR FLOW	CFM	1.0 MIN.	ASTM 1564
RESILIENCE (BALL TEST)	%	60.0 MIN.	ASTM 3574
TENSION TEST			
- TENSILE STRENGTH	PSI	15.0 MIN.	ASTM 3574
- ULTIMATE ELONGATION	%	100 MIN.	ASTM 3574
GRIP SEPARATION			
TEAR RESISTANCE	PLI	1.50 MIN.	ASTM 3574
STATIC FATIGUE 75%			
- I. F. D. LOSS @ 25%	%	10 MAX.	ASTM 3574
- THICKNESS LOSS			
@ 75% COMPRESSION	%	1 MAX.	ASTM 3574

FLAMMABILITY PERFORMANCE *

- CALIFORNIA TECHNICAL BULLETIN 117, SEC. A, PART I PASS
- CALIFORNIA TECHNICAL BULLETIN 117, SEC. D, PART II PASS
- FEDERAL M.V.S.S. 302 PASS
- * FAA, FAR 25.853 (B) MEETS

- THIS FLAMMABILITY DATA IS NOT INTENDED TO REFLECT HAZARD PRESENTED BY THIS OR ANY OTHER MATERIAL UNDER ACTUAL FIRE CONDITIONS.

NOTE: FAA, FAR 25.853 (B) MUST BE TESTED EACH RUN BY A INDEPENDENT CERTIFIED LAB TO CERTIFY FOR USE ON AIRCRAFT. THIS MATERIAL HAS BEEN TESTED AND MEETS THIS STANDARD.

The above specifications have been reviewed and approved.

Signature

Title

Date